Date: Tuesday, 7/3/2007 2:43:20 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKID TUBE ASSEMBLY
Job Number	: 33274		
Estimate Number	: 12520		
P.O. Number	: N/A	**Part Number**	: D205634045
This Issue	: 7/3/2007 **S.O. No.** : N/A	**Drawing Number**	: D2580 REV C/DEO9183B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: C/B
Previous Run	: 33273	**Material**	: N/A
Written By	:	**Due Date**	: 7/13/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.07.03		
Comment	: Est Rev:C Revised Steps 06-09-06 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG001 07.07.03

2.0	D25001190	

Comment: Qty.: 1.04000 Each(s)/Unit Total : 1.04000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B29602

JD 7-7-3

3.0	D2596	

Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B33058

JD 7-7-4

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

JD 7-7-3

JD 7-7-4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** ____ **Date:** _____

QA: N/C Closed: ____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:20 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33274

Part Number: D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

JD 7-7-4

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

JD 7-7-4

Pick:

Qty	Part Number	Description	Batch
A/R		Sikaflex-291	M 104732

Sikaflex expire date: 8-1-1

Start Time: 11:15 Date: 7-7-4

Fin Time: 6:45 Date: 7-7-5

5.0 BENDING — BENDING MACHINE

Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

BL 7-7-5

6.0 LANDING GEAR 1 — LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

2-Drill extra fwd hole as per DEO 9183 using drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using drill jig DT8462

4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN TO FINISH SIZE***

5-Drill extra aft holes as per DEO 9183 using drill jig DT8463 locating from aft cap hole and aft saddle hole.

pm 07-07-07

7.0 QC5 — INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

BE 07 0709

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE :**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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Date: Tuesday, 7/3/2007 2:43:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 33274 **Part Number:** D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
8.0	D25763	

Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B29486 BE 07-07-09

9.0	D2579		

Comment: Qty.: 24.00000 Each(s)/Unit Total : 24.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
24	D2579	Spacers	B32026 BE 07-07-09

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 07-07-09

2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod M104305 BE 07-07-09

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod M104305 BE 07-07-09

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes
**********DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384"Ø AS PER DEO 9183)****

7-Open aft cap holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

7-7-10

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY
Job Number: 33274
Part Number: D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION AD 07-07-13 (1)

12.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP EN 07/07/12 (+1)

13.0	POWDER COATING	POWDER COATING

WATER PRESSURE RL 07-07-12
M. 18144

Comment: POWDER COATING (1)
Powder Coat ****GREEN****Sandtex (Ref: 4.3:5.8) as per QSI 005 4.3 BR FR 07-07-13

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 07/7/13 (1)

15.0	D25771

Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B31212

16.0	D25773

Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B30551

17.0	D25775

Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	B31254

RL 07.07.13 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B				**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng		**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 33274 **Part Number:** D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	ALS71032130	

Comment: Qty.: 44.00000 Each(s)/Unit Total : 44.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	M103495

19.0	AN960JD10L		

Comment: Qty.: 44.00000 Each(s)/Unit Total : 44.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	M103641

20.0	AN34A		

Comment: Qty.: 44.00000 Each(s)/Unit Total : 44.00000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	M104817

21.0	D25941		

Comment: Qty.: 16.00000 Each(s)/Unit Total : 16.00000 Each(s)
plug
Batch: B32651

22.0	D25943		

Comment: Qty.: 16.00000 Each(s)/Unit Total : 16.00000 Each(s)
o-ring
Batch: B27168

23.0	D2855		

Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)
Cap
Batch: B33447

07-07-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 33274 **Part Number:** D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	AN35A	

Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)
Bolt
Batch: M100588

25.0	AN960JD10L	

Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)
Washer
Batch: M 103641 07.02.16 (B)

26.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M104616
Sikaflex expire date: 07.09

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 M1046 16
Sikaflex expire date: 07-09

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
M104733 Batch: 07/07/16 O

07-07-16 O

27.0	QC5	INSPECT WORK TO CURRENT STEP

For 07/07/17 All Plugs are installed (KL)

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-045
Location:
PPP Rev: PPP 3296 I

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** Q **Date:** 07/07/23

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 7/3/2007 2:43:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 33274 **Part Number:** D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
29.0	QC21	FINAL INSPECTION/W/O RELEASE

07.07.17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

07-07-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
98/09/17 DS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
GP 00.08.28

EFFECTIVE DEOs
DEO 9183
DEO 9216

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
   POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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WORK ORDER
NO. 33274

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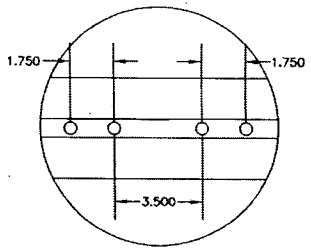
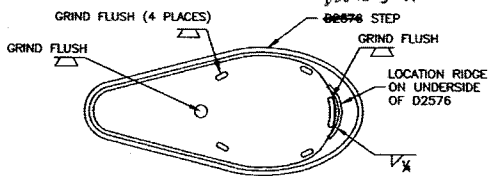
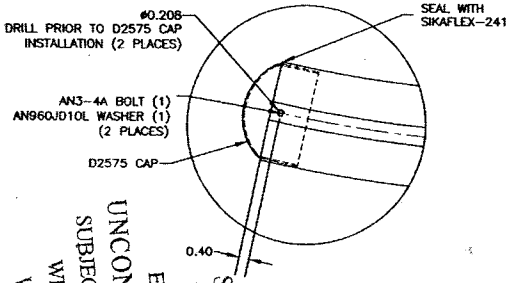
DETAIL A
SCALE 5:24



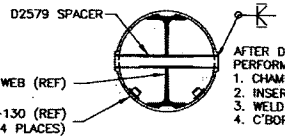
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24

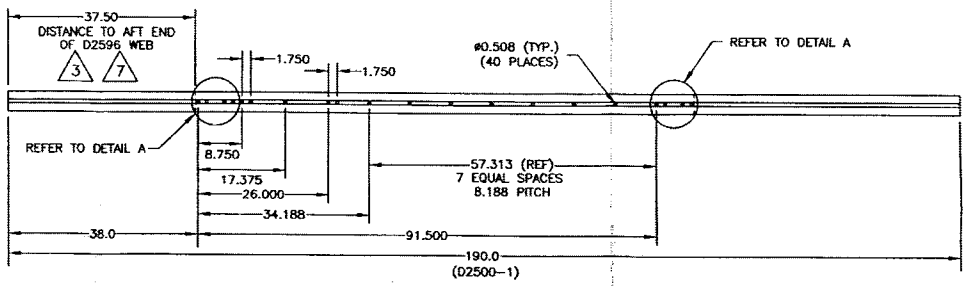


SECTION D-D
SCALE 5:24

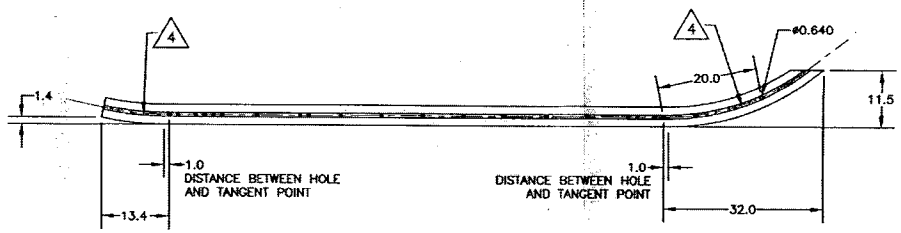


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

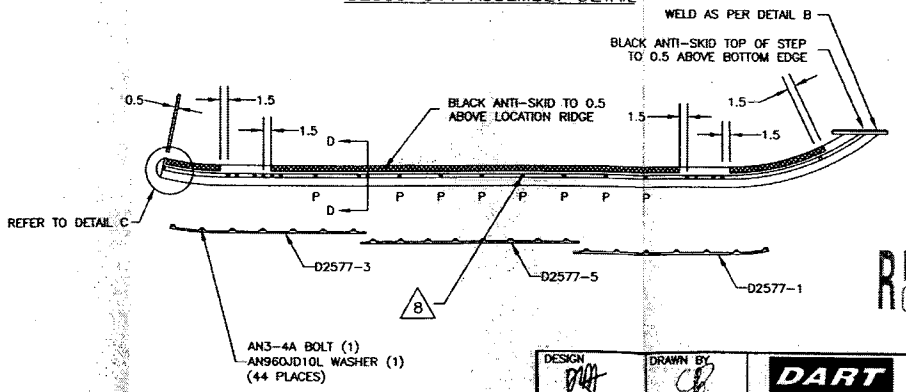
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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RELEASED 98/09/17 DS

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. C SHEET 2 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	RF		
CHECKED	APPROVED	DRAWING NO.	REV. B
		DEO 9183	SHEET 1 OF 1
DATE		TITLE	SCALE
00.05.15		ADD SKIDTUBE P/N D2580-045	NTS

A	00.03.29	NEW ISSUE
B	00.05.15	39.580 WAS 39.620

DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045 ASSEMBLY

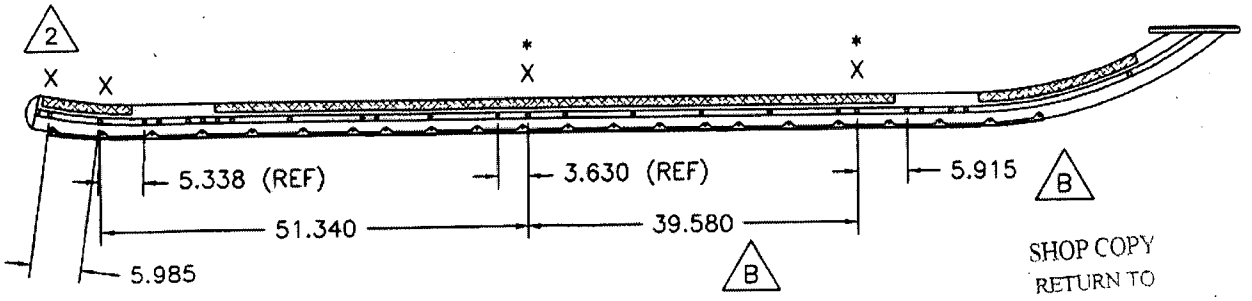
D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.

   a) DRILL Ø0.508 HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES 0.030 x 45°. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO Ø0.63 AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
   b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
   c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
   d) REMOVE SPILL OVER LEAVING HOLE DIMENSION Ø0.380-Ø0.390.

2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.

3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
RF	RF	
CHECKED	APPROVED	DRAWING NO. REV. A
		DSI 9184 SHEET 1 OF 1
DATE		TITLE SCALE
00.03.29		ADD SKIDTUBE P/N D205-634-015 NTS
A	00.03.29	NEW ISSUE

DART SERVICE INSTRUCTION

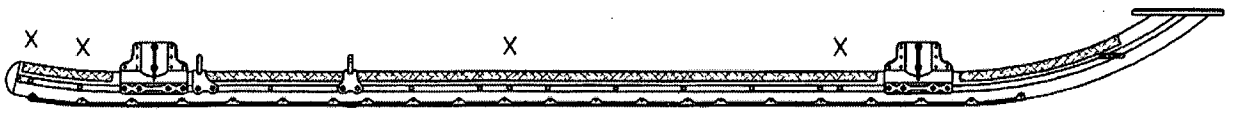
TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B.

REF. CANADIAN STA: SH96-88
US FAA STC: SR00563NY

ADD D205-634-015 INSTALLATION. PARTS LIST IS IDENTICAL TO PARTS LIST FOR D205-634-011 EXCEPT THAT:

D205-634-045	REPLACES	D205-634-041
D2580-045	REPLACES	D2580-041

THE DIFFERENCE BETWEEN D205-634-011 (D205-634-041) AND D205-634-015 (D205-634-045) IS THAT EXTRA SPACERS HAVE BEEN ADDED AT LOCATIONS MARKED 'X' AND ASSEMBLY IS PAINTED GREEN.



D205-634-015 (D205-634-045)

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NO. 115

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 1205634045 / 633273

TEST WELDS REQUIRED

BASE METAL Alum
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS Tig
Single Weld [✓] **Double Weld** [ ]
Backing YES [ ] NO [✓]

Position **Vertical** Down [ ] Up [ ]

Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/09 **Qualifier** David Lewis